

# Work Order ID 53157

October 23, 2009 10:55:42 AM



Page 1

Item ID: D3983-5

Accept



Setup Start



Revision ID: A

Stop



Item Name: Hinge Closeout

Start Date: 23/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: PA

Date: 09-10-23

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3983

A

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3983

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

0.00

09-10-28

(10)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

09-10-28

**Work Order ID 53157**

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Page 2

Item ID: D3983-5

Accept



Setup Start



Revision ID: A

Stop



Item Name: Hinge Closeout

Start Date: 23/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00

SB 09/10/28

(x10)

/

QC

Memo

0.00

Quality Control

130

Bend as per dwg

0.00

SB 09/10/04

10

/

Brake NC

Memo

0.00

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00

SB 09/10/05

(x10)

/

QC

Memo

0.00






Quality Control

**Work Order ID 53157**



October 23, 2009 10:55:43 AM




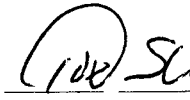


Page 3

Item ID: D3983-5 Accept  Setup Start   
Revision ID: A Stop   
Item Name: Hinge Closeout  
Start Date: 23/10/2009 Start Qty: 10.00  Cust Item ID:  
Required Date: 30/10/2009 Req'd Qty: 10.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start   
Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00	ll	09/11/05		X10	6		
160  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00	mo	09/11/05		X10			
170  Packaging Packaging	Identify as per dwg & Stock Location: _____  Memo	0.00 0.00							9/11/05 

**Work Order ID 53157**

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October 23, 2009 10:55:43 AM

Item ID: D3983-5

Accept



Setup Start



Revision ID: A

Stop



Item Name: Hinge Closeout

Start Date: 23/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/09 AJ

MF 09-11-09

# Picklist Print

October 23, 2009 10:55:46 AM

Page 1

Work Order ID: 53157



Parent Item: D3983-5



Parent Item Name: Hinge Closeout

Start Date: 23/10/2009

Required Date: 30/10/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M6061T6S.040

Purchased

No

100

sf

90.3986

1.5137



13 9-10-28

6061-T6 .040 Sheet

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

90.3986

100742

3.3

102723

5.93

105842

12

106747

5.7516

107461

11.7841

109396

22.28

111224

27.8529

19380

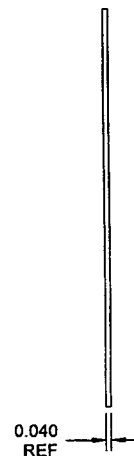
1.5

113004

113004





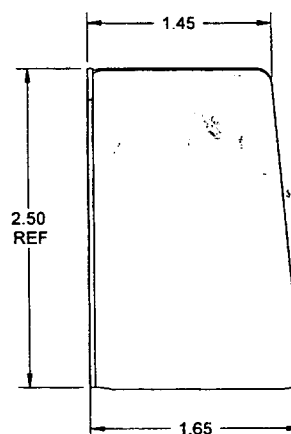
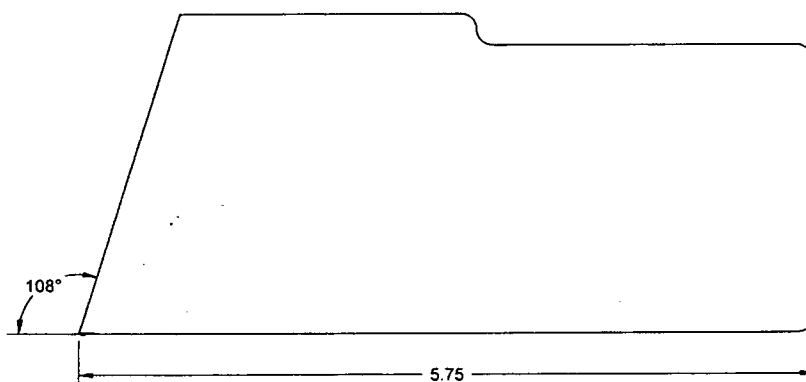
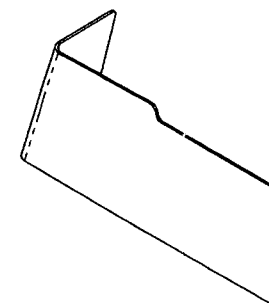
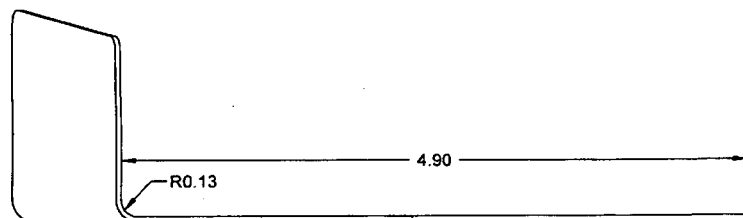


W/O 53157

RELEASED  
2009-10-13

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D3983</b>  TITLE <b>CLOSE OUT KIT</b>  COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD</small>	REV. A
DRAWN	<i>[Signature]</i>		SHEET 2 OF 7
CHECKED	<i>[Signature]</i>		SCALE
MFG. APPR.	<i>[Signature]</i>		NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	09.09.09		





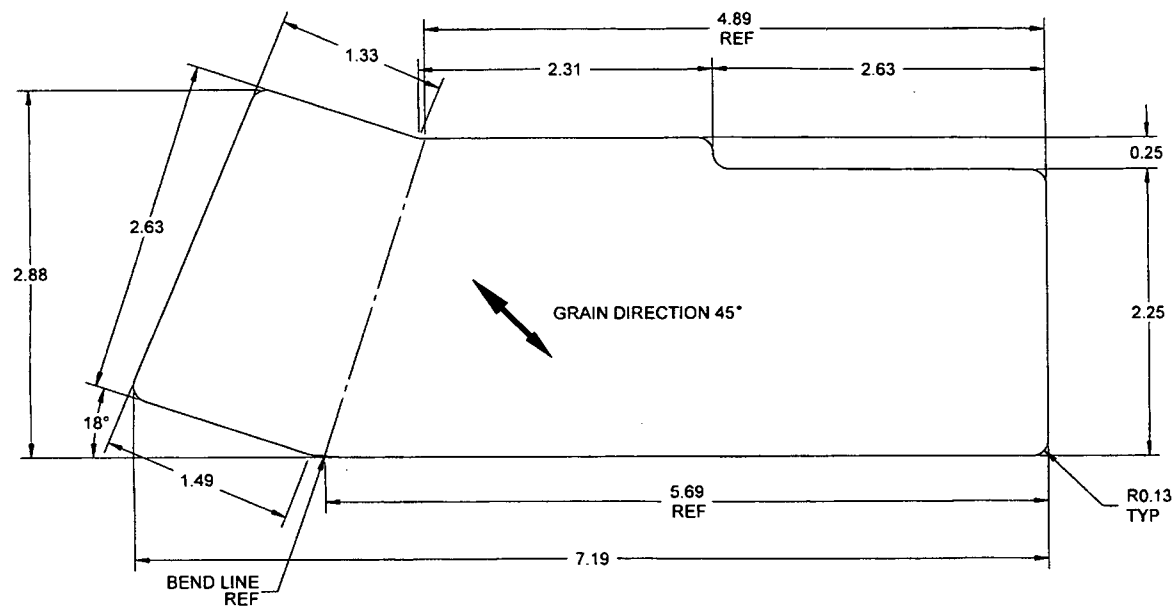
W/ 53157

**D3983-5 HINGE CLOSEOUT**  
(MADE FROM D3983-5F)

**RELEASED**  
2009-10-13

NOTES:  
MATERIAL: D3983-5F  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
UNITS: INCHES UNLESS OTHERWISE NOTED  
BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
IDENTIFICATION: IDENTIFY WITH DART P/N "D3983-5" AND B/N USING FINE POINT PERMANENT INK MARKER  
WEIGHT: 0.06 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3983	SHEET 3 OF 7
APPROVED		TITLE	SCALE
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**D3983-5F HINGE CLOSEOUT FLAT PATTERN**

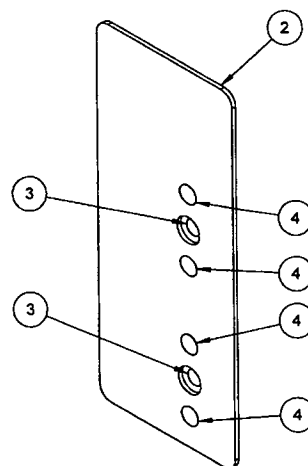
**RELEASED**  
2009-10-13  
*MP*

NOTES:  
MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.040

FINISH: N/A  
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
UNITS: INCHES UNLESS OTHERWISE NOTED  
BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
IDENTIFICATION: N/A  
WEIGHT: 0.06 lbs

DESIGN	<i>JS</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>JS</i>		
CHECKED	<i>JS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JS</i>	D3983	SHEET 4 OF 7
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	CLOSE OUT KIT	NTS
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ITEM	QTY. -047	PART NUMBER	DESCRIPTION
1	X	D3983-047	CLOSEOUT ATTACHMENT
2	1	D3983-7	PLATE
3	2	MS21059L3	ANCHOR NUT
4	4	MS20426AD3-4	RIVET



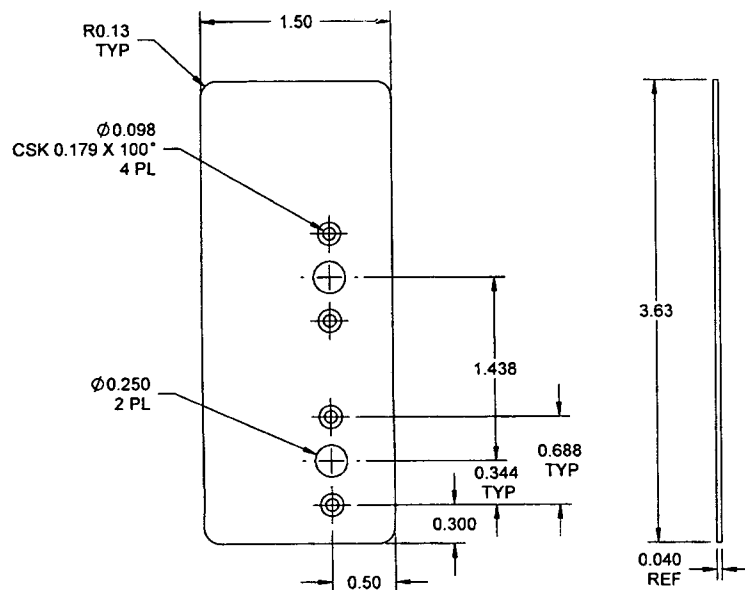
w/o 53157

**D3983-047 CLOSEOUT ATTACHMENT**

**RELEASED**  
2009-10-13  
MD

NOTES:  
 MATERIAL: SEE BOM  
 FINISH: N/A  
 TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 UNITS: INCHES UNLESS OTHERWISE NOTED  
 BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 IDENTIFICATION: IDENTIFY WITH DART P/N "D3983-047" AND B/N USING FINE POINT PERMANENT INK MARKER  
 WEIGHT: 0.03 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3983	SHEET 5 OF 7
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**D3983-7 PLATE**

*w/o 53157*

**RELEASED**  
2009-10-13  
*MD*

**NOTES:**  
MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.040  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
UNITS: INCHES UNLESS OTHERWISE NOTED  
BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
IDENTIFICATION: N/A  
WEIGHT: 0.02 lbs

DESIGN	<i>JS</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>JS</i>		
CHECKED	<i>JS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JS</i>	D3983	SHEET 6 OF 7
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	CLOSE OUT KIT	NTS
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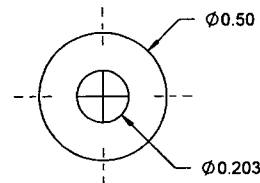
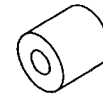
5

4

3

2

1



w/0.53/57

**D3983-9 SPACER**

**RELEASED**  
2009-10-13  
MP

**NOTES:**

MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR,  $\varnothing 0.500$   
 PER AMS-QQ-A-225/8 (OR AMS 4117/4122/4128/4115/4116) OR  
 PER AMS-QQ-A-200/8 (OR AMS 4160)  
 REF DART SPEC M6061TR

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

UNITS: INCHES UNLESS OTHERWISE NOTED

BREAK SHARP EDGES: 0.005 TO 0.010 MAX

IDENTIFICATION: IDENTIFY WITH DART P/N "D3983-9" AND B/N USING FINE POINT PERMANENT INK MARKER

WEIGHT: 0.01 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3983	SHEET 7 OF 7
APPROVED		TITLE	SCALE
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